

# Work Order ID 86755

July-06-12 2:17:16 PM

**\*86755\***

Page 1

Item ID: D2232-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Hinge  
 Start Date: 7/06/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 8/03/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: H Date: 12-07-9 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2232	Rev C								

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2232

Dwg Rev: C

Prog Rev: C 2-

Deburr if necessary

304 .125

6 0 Jun 12-7-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

6 0 Jun 12-7-13

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
16  
8-83  
12/07/16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*86755\***

July-06-12 2:17:16 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*6\***

**Cust Item ID:**

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

Identify as per dwg & Stock Location:

0.00

**\*130\***

### Packaging

## Memo

0.00

### Packaging

\*\*\*\*\*STOCK IN BASKET CELL\*\*\*\*\*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

6x *SS* 12.07.18

12/7/19 *SS*

*MF*

12-07-18

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 2:17:15 PM

Page 1

Work Order ID: 86755

Parent Item: D2232-1

Parent Item Name: Basket Hinge

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPPB01.06.07Now laser cutEC  
IPP Rev:C Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA  
304/316 0.125 Sheet

Purchased

No

100

sf

45.0260

0.0243

0.1534737

0, 2

Jun 12-713

Location

Loc Qty

Loc Code

MAT020

45.026

121380

23.9

121780

21.126

121380

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

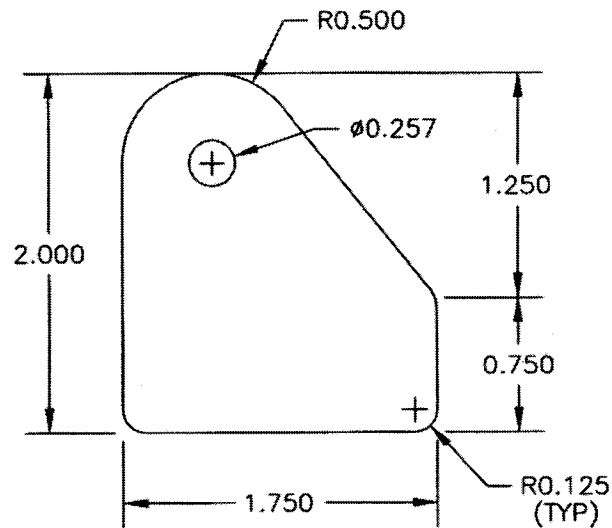


**DART**



**RELEASED**  
98.05.05 KE

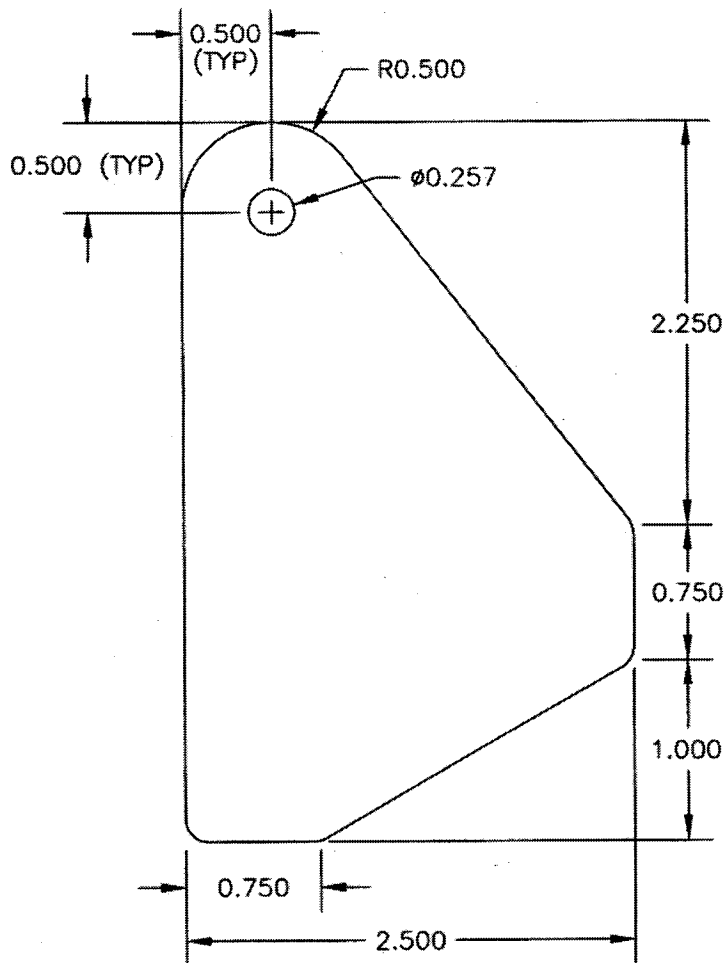
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	D2232	SHEET 1 OF 2	
DATE		TITLE	BASKET HINGE	SCALE	1:1
98.04.28					
A	94.05.12	NEW ISSUE			
B	96.01.02	ADDED - 5 AND - 7			
C	98.04.28	0.125 THICK WAS 0.063			



D2232-1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 16755

*012-07-9*



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

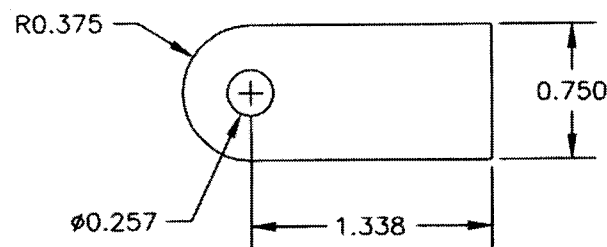
**DART**



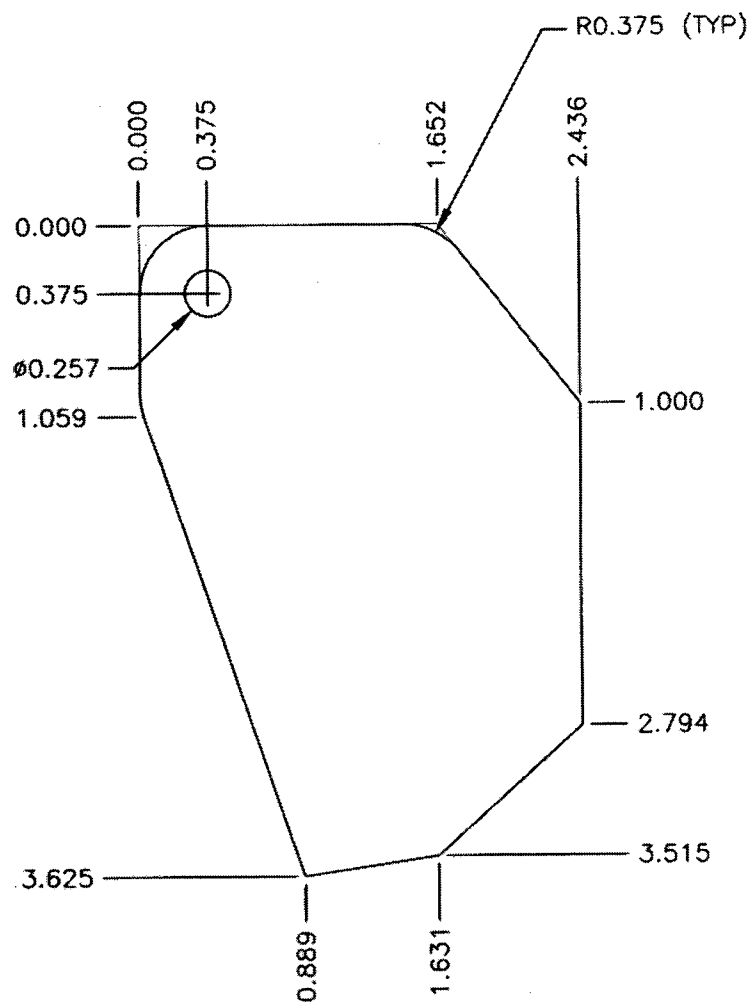
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D2232	SHEET 2 OF 2
98.04.28		TITLE	SCALE
		BASKET HINGE	1:1

**RELEASED**  
98.05.05 KE

76755



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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